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UTILITY PATENT APPLICATION TRANSMITTAL
(Large Entity)

(Only for new nonprovisional applications under 37 CFR 1.53(b))

Docket No. 13368
Total Pages in this Submission

jc858 U.S. PTO 06/21/00

TO THE ASSISTANT COMMISSIONER FOR PATENTS
Box Patent Application
Washington, D.C. 20231

Transmitted herewith for filing under 35 U.S.C. 111(a) and 37 C.F.R. 1.53(b) is a new utility patent application for an invention entitled:

ROTATING MACHINE WITH COOLED HOLLOW ROTOR BARS

jc829 U.S. PTO 09/598731 06/21/00

and invented by:

Roy R. Weidman, et al.

If a **CONTINUATION APPLICATION,** *check appropriate box and supply the requisite information:*

☐ **Continuation** ☐ **Divisional** ☐ **Continuation-in-part (CIP)** of prior application No.: _____

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Enclosed are:

Application Elements

1. ☒ Filing fee as calculated and transmitted as described below
2. ☒ Specification having 26 pages and including the following:
   - a. ☒ Descriptive Title of the Invention
   - b. ☐ Cross References to Related Applications *(if applicable)*
   - c. ☐ Statement Regarding Federally-sponsored Research/Development *(if applicable)*
   - d. ☐ Reference to Microfiche Appendix *(if applicable)*
   - e. ☒ Background of the Invention
   - f. ☒ Brief Summary of the Invention
   - g. ☒ Brief Description of the Drawings *(if drawings filed)*
   - h. ☒ Detailed Description
   - i. ☒ Claim(s) as Classified Below
   - j. ☒ Abstract of the Disclosure

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Application Elements (Continued)

3. ☒ Drawing(s) *(when necessary as prescribed by 35 USC 113)*
   a. ☒ Formal Number of Sheets 4
   b. ☐ Informal Number of Sheets

4. ☒ Oath or Declaration
   a. ☒ Newly executed *(original or copy)* ☐ Unexecuted
   b. ☐ Copy from a prior application (37 CFR 1.63(d)) *(for continuation/divisional application only)*
   c. ☒ With Power of Attorney ☐ Without Power of Attorney
   d. ☐ *DELETION OF INVENTOR(S)*
   Signed statement attached deleting inventor(s) named in the prior application, see 37 C.F.R. 1.63(d)(2) and 1.33(b).

5. ☐ Incorporation By Reference *(usable if Box 4b is checked)*
The entire disclosure of the prior application, from which a copy of the oath or declaration is supplied under Box 4b, is considered as being part of the disclosure of the accompanying application and is hereby incorporated by reference therein.

6. ☐ Computer Program in Microfiche *(Appendix)*

7. ☐ Nucleotide and/or Amino Acid Sequence Submission *(if applicable, all must be included)*
   a. ☐ Paper Copy
   b. ☐ Computer Readable Copy *(identical to computer copy)*
   c. ☐ Statement Verifying Identical Paper and Computer Readable Copy

Accompanying Application Parts

8. ☒ Assignment Papers *(cover sheet & document(s))*

9. ☐ 37 CFR 3.73(B) Statement *(when there is an assignee)*

10. ☐ English Translation Document *(if applicable)*

11. ☐ Information Disclosure Statement/PTO-1449 ☐ Copies of IDS Citations

12. ☐ Preliminary Amendment

13. ☒ Acknowledgment postcard

14. ☒ Certificate of Mailing
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Docket No. 13368
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Accompanying Application Parts (Continued)

15. ☐ Certified Copy of Priority Document(s) *(if foreign priority is claimed)*

16. ☐ Additional Enclosures *(please identify below):*

Fee Calculation and Transmittal

CLAIMS AS FILED

For	#Filed	#Allowed	#Extra	Rate	Fee
Total Claims	26	- 20 =	6	x $18.00	$108.00
Indep. Claims	2	- 3 =	0	x $78.00	$0.00
Multiple Dependent Claims (check if applicable) ☐					$0.00
				BASIC FEE	$690.00
OTHER FEE *(specify purpose)*					$0.00
				TOTAL FILING FEE	$798.00

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Signature

Dated: **June 21, 2000**

Paul J. Esatto, Jr.
Registration No. 30,749

Scully, Scott, Murphy & Presser
400 Garden City Plaza
Garden City, New York 11530
(516) 742-4343

cc:

CERTIFICATE OF MAILING BY "EXPRESS MAIL" (37 CFR 1.10)	Docket No.
Applicant(s): **Roy R. Weidman, et al.**	**13368**

Serial No.	Filing Date	Examiner	Group Art Unit
To be assigned	**Herewith**	**Unassigned**	**Unassigned**

Invention: **ROTATING MACHINE WITH COOLED HOLLOW ROTOR BARS**

JC829 U.S. PTO 09/59873 06/21/00

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ROTATING MACHINE WITH COOLED HOLLOW ROTOR BARS

BACKGROUND OF THE INVENTION

1. Field of the Invention

The present invention relates generally to rotating machines such as electric motors and generators and, more particularly, to electric motors and generators having a current-carrying stator with an induced current in a rotating inner rotor with coolant passing through the current carrying portion of the rotor.

2. Prior Art

There have been many proposals intended to improve the operation of transducers for electrical power/mechanical power conversion (motors or generators). However, there are still areas where the use of electric motors remains impractical, for example for use as the main drive of a vehicle such as a car. Current electric motors are generally too large, heavy, and produce too little power (especially at high speed) for commercial use in a vehicle such as a car.

One problem associated with electrical machines, such as electric motors, is that it is necessary to cool them because they generate heat which reduces their efficiency. The need for optimization in cooling is even more important as increases in performance demands smaller packages. At present such machines may be cooled by blowing air through or over them. For heavy duty applications it is known to spray oil onto the rotor and stator assemblies and into the gap between them using a high pressure pump. A scavenger pump

may also be provided to collect the sprayed oil for re-cycling.

A common configuration for such motors is to have an inner rotor mounted on a straight shaft supported by bearings on the ends. The bearings are mounted in end covers that support and locate the rotor in the center of a current-carrying stator. The rotor contains multiple current-carrying bars which run length wise parallel to the shaft and are located near the outer circumference of the rotor. Heat is produced in the rotor when the current in the stator excites the bars. Heat dissipation limits the design of the rotor. Another method used to dissipate heat is to pass oil coolant through a hollow rotor shaft, referred to as back iron cooling. Heat generated in the rotor conductor bars is dissipated into the core of the rotor, then into the rotor shaft and then into the oil coolant flowing through the shaft and exits the rotating machine to a heat exchanger. Although this cooling method has its advantages, such as simplicity in design, it is desirable to increase the amount of heat conduction away from the rotor bars of the motor and to concentrate the cooling at the source of the heat, namely, the rotor bars.

SUMMARY OF THE INVENTION

Therefore it is an object of the present invention to provide a rotating machine with cooled hollow rotor bars which provides an increased amount of cooling than is provided by prior art methods for cooling rotating machines.

In order to increase heat conduction away from a plurality of rotor bars of a rotating machine, oil coolant is passed through the rotor bars. Oil coolant is supplied to and removed from the rotor bars via left and right end plates. The end plates are preferably round disks located on either end of the rotor. The end plates have conduits therein to allow the flow of coolant oil in the rotor bars on one end and out on the other end. Holes located in a rotating hollow shaft under each end plate and communicating with the conduits of the end plates allow oil coolant to flow in and out of the hollow shaft. A restriction located near the middle of the hollow shaft and between the end plates provides a pressure differential to divert at least a portion of the coolant oil to flow through the rotor bars.

In summary, there is provided an improved rotating machine. The improved rotating machine comprises: a rotating shaft: a plurality of conductive rotor bars spaced from the rotating shaft and fixed thereto through at least one intermediate member, at least one of the plurality of conductive rotor bars having at least one first internal conduit; and circulation means for establishing a coolant circulation through the first internal conduit.

In a preferred implementation of the rotating machine, the rotating shaft has a first wall defining a second internal conduit extending from an inlet end to an outlet end thereof. The rotating shaft further has first and second coolant holes in the wall and communicating with the second internal conduit, wherein the coolant is circulated through the first internal conduit from the second internal conduit by way of the first and second

coolant holes. Furthermore, each of the plurality of conductive rotor bars have a first and second end where the at least one first internal conduit extends from the first to second end. A first end plate has a first bore in which the rotating shaft is sealingly fixed in proximity to the first coolant hole. The first end plate further has means for sealingly fixing the first end of each conductive rotor bar having the at least one first internal conduit thereto and a third internal conduit for each of the plurality of conductive rotor bars having the at least one first internal conduit for providing communication between the first coolant hole and the first end of the first internal conduit. A second end plate has a second bore in which the rotating shaft is sealingly fixed in proximity to the second cooling hole. The second end plate further has means for sealingly fixing the second end of each conductive rotor bar having the at least one first internal conduit thereto and a fourth internal conduit for each of the plurality of conductive rotor bars having the at least one first internal conduit for providing communication between the second coolant hole and the second end of the first internal conduit. Thus, the circulation of coolant is established through the first, second, third, and fourth internal conduits for each conductive rotor bar having the at least one second internal conduit.

The circulation means comprises either a full restriction plug disposed in the second internal conduit between the first and second coolant holes thereby diverting all of the fluid flow through the first, third, and fourth internal conduits for each conductive rotor bar having the at least one first internal conduit.

Alternatively, the circulation means comprises a partial restriction plug disposed in the second internal conduit between the first and second coolant holes. Thus, in the alternative version, which is also the preferred implementation, a portion of the fluid flow is diverted through the first, third, and fourth internal conduits for each conductive rotor bar having the at least one first internal conduit and the remaining portion of the fluid flow continues through the second internal conduit of the rotating shaft.

In yet another preferred implementation of the rotating machine of the present invention, each of the plurality of conductive rotor bars have the at least one first internal conduit. In yet a more preferred implementation of the rotating machine of the present invention, the at least one first internal conduit comprises two first internal conduits, each extending from the first to second end of the conductive rotor bars.

In yet another preferred implementation of the rotating machine of the present invention, each of the first and second end plates further has an access bore disposed in a fluid path of the third and fourth internal conduits, respectively, for facilitating the fabrication of the third and fourth internal conduits, and wherein the first and second end plates each further comprise a cover plate sealingly covering its respective access bore.

In yet still another preferred implementation of the rotating machine of the present invention, the rotating machine further comprises: a circulation conduit connecting the inlet end of the rotating shaft to the

outlet end of the rotating shaft; a pump disposed in a fluid path of the circulation conduit for establishing a fluid flow into the inlet end, through the first, second, third, and fourth internal conduits for each conductive rotor bar having the at least one first internal conduit, and out the outlet end; and a heat exchanger disposed in the fluid path of the circulation conduit for removing heat from the fluid flowing therein.

Also provided is a method for assembling the rotating machine of the present invention. The method comprises the steps of: assembling the plurality of conductive rotor bars to the at least one intermediate member and the first end of each conductive rotor bar having the at least one internal conduit to the first end plate; heating the top region of a molten salts bath such that the top region is maintained at a normal brazing temperature; only immersing the first end plate and the first ends of the plurality of conductive rotor bars into the top region of the molten salts bath; salts brazing the first end of each conductive rotor bar having the at least one internal conduit to the first end plate; either before or after the salts brazing of the first end of each conductive rotor bar having the at least one internal conduit, assembling the second end plate to the second end of each rotor bar having the at least one internal conduit to the second end plate; only immersing the second end plate and the second ends of the plurality of rotor bars into the top region of the molten salts bath; and salts brazing the second end of each conductive rotor bar having the at least one internal conduit to the second end plate.

BRIEF DESCRIPTION OF THE DRAWINGS

These and other features, aspects, and advantages of the apparatus and methods of the present invention will become better understood with regard to the following description, appended claims, and accompanying drawings where:

Figure 1 illustrates a sectional view of the rotating machine of the present invention.

Figure 2a illustrates a sectional view taken through line 2a-2a of Figure 1.

Figure 2b illustrates a partial exploded view of the sectional view of Figure 2a.

Figure 3a illustrates a sectional view of the rotor of the rotating machine of Figure 1 taken through line 3-3 thereof.

Figure 3b illustrates an enlarged sectional view of a rotor bar of Figure 3a.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

Although this invention is applicable to numerous and various types of rotating machines, it has been found particularly useful in the environment of electric motors and generators. Therefore, without limiting the applicability of the invention to electric motors and generators, the invention will be described in such environment.

Referring now to Figure 1, there is illustrated a sectional view through the end covers 102, bearings 104, and stator 106 of a rotating machine of the present invention, the rotating machine generally referred to by reference numeral 100 and depicted therein as an electric motor. The rotating machine 100 generally has a

rotating shaft 108 rotatably supported in the end covers 102 by the bearings 104. The rotating shaft 108 rotates the rotor assembly 110 relative to the stator 106.

Referring now to Figures 2a and 2b, there is illustrated the rotor assembly 110 of Figure 1 in greater detail. The rotating shaft 108 generally is hollow or tubular and thus has a wall 108a defining a second internal conduit 108b extending from an inlet end 112 to an outlet end 114 thereof. The second internal conduit 108b is used to carry cooling fluids, such as oil through the shaft to cool the shaft, and as will be described below, to also cool the conductive rotor bars. The fluid flow is shown as traveling in the direction from the inlet end 112 to the outlet end 114, however, those skilled in the art will recognize that the fluid flow can travel from end 114 to end 112 without departing from the spirit or scope of the present invention. The rotating shaft 108 further has first and second coolant holes 116, 118 in the wall 108a and communicating with the second internal conduit 108b.

Referring now to Figures 2a, 2b, and 3a in combination, a plurality of conductive rotor bars 120 (hereinafter referred to as rotor bars) are spaced from the rotating shaft 108 and fixed thereto through at least one intermediate member. The at least one intermediate member preferably comprises a plurality of parallel stacked steel laminates 122. Each steel laminate typically has a central bore 122a for acceptance of the rotating shaft 108 therein and a slot 122b corresponding to each of the plurality of rotor bars 120 for acceptance of each of the plurality of rotor bars 120 therein. Each of the plurality of rotor bars 120 has a first and second

end 120a, 120b, respectively. At least one of the plurality of rotor bars 120 has a first internal conduit 124 extending from the first to second end 120a, 120b of the rotor bar 120.

Referring now to Figure 3b, preferably, each of the plurality of rotor bars 120 has the first internal conduit 124. More preferably, each of the rotor bars 120 has two first internal conduits 124, 126. The first internal conduits 124, 126 are preferably cylindrical (circular in cross-section) for ease of fabrication. The rotor bars are preferably teardrop-shaped as shown in Figure 3b, having one end (closest to the stator 106) which is larger in cross-section than an opposite end. At least one of the first internal conduits is preferably located at that part of the rotor bar 120 which has the larger (or increased) cross-section. This concentrates the cooling fluid in the rotor bar at the point where heat generated is the greatest and thus increases the cooling efficiency thereof.

Referring back to Figures 2a and 2b, the rotor assembly 110 further has first and second end plates 128a, 128b on either ends 120a, 120b of the rotor bars 120. The first end plate 128a has a first bore 130a for accepting the rotating shaft 108. The first end plate is fixed and sealed to the rotating shaft 108 with the first end plate 128a being in proximity to the first coolant hole 116. The first end plate 128a is sealed to the rotating shaft by means of first and second o-ring seals 132a, 134a, disposed on either side of the first coolant hole 116 to prevent any fluid from flowing between the outer surface of the rotating shaft 108 and the inner surface of the first bore 130a. The first end plate 128a

can be fixed to the rotating shaft 108 in any manner known in the art. Preferably, the first end plate 128a is shrink fit to the rotating shaft 108. Shrink fitting comprises heating the first end plate 128a so as to expand the diameter of the first bore 130a and/or (preferably, and) cooling the rotating shaft 108 so as to decrease the outer diameter thereof. The first end plate 128a is thereafter assembled in place on the rotating shaft 108 and the temperatures of the first end plate 128a and/or the rotating shaft 108 are normalized (e.g., brought to room temperature) such that the first end plate 128a is shrunk fit to the rotating shaft 108. The shrink fit also provides the proper o-ring squeeze to provide a proper liquid seal between the first end plate 128a and the rotating shaft 108.

The first end plate 128a further has means for sealingly fixing the first end 120a of each rotor bar 120, having the at least one first internal conduit 124, to the first end plate 128a. The rotor bars 120 are preferably located in position relative to the first end plate 128a by insertion of their first end 120a into corresponding counterbore 136a on the first end plate 128a. The counterbore 136a preferably has a shape and size substantially the same as the cross sectional shape and size of the rotor bar 120 so as to also orient the rotor bars 120 in their correct angular position.

The first end plate 128a is preferably disc-like in shape and both the first end plate 128a and the rotor bars 120 are fabricated from aluminum. The means for sealingly fixing the first end 120a of each rotor bar 120 to the first end plate 128a comprises a brazed joint

at the juncture between the first end plate 128a and the first end 120a of the rotors 120.

The first end plate further has a third internal conduit, referred to generally by reference numeral 138a. The third internal conduit provides fluid communication between the first coolant hole 116 and the first end 120a of the first internal conduit 124 (and alternatively both second conduits 124, 126) for all of the rotor bars 120 having first internal conduit(s) 124 (126). The first end plate preferably has a groove 140a on the first bore 130a in proximity to the first coolant hole 116 so that the first coolant hole 116 is in communication with the groove 140a and the groove 140a is in communication with all of the third internal conduits 138a.

Preferably, the first end plate 128a further has an access groove 142a disposed in a fluid path of the third internal conduit 138a. Because the first end plate 138a is typically a thin plate, the access groove 142a facilitates easy fabrication of the third internal conduit 138a. The access groove 142a of the first end plate 128a is then sealingly covered with a cover plate 144a. The cover plate 142a is also preferably aluminum and brazed to the first end plate 128a.

Referring to Figure 2a, similarly, the second end plate 128b has a second bore 130b for accepting the rotating shaft 108. The second end plate 128b is fixed and sealed to the rotating shaft 108 in the same manner as is the first end plate 128a but with respect to the second coolant hole 118 and the second ends 120b of the rotor bars 120. The second end plate 128b is sealed to the rotating shaft 108 by means of third and fourth o-

ring seals 132b, 134b, disposed on either side of the second coolant hole 118 to prevent any fluid from flowing between the outer surface of the rotating shaft 108 and the inner surface of the second bore 130b.

The second end plate 128b further has means for sealingly fixing the second end 120b of each rotor bar 120 having the at least one first internal conduit 124 to the second end plate 128b. The rotor bars 120 are also preferably located in position relative to the second end plate 128b by insertion of their second end 120a into a corresponding counterbore 136b on the second end plate 128b. The counterbore 136b preferably has a shape and size substantially the same as the cross sectional shape and size of the rotor bar 120 so as to also orient the rotor bars 120 in their correct angular position.

The second end plate 128b is preferably disc-like in shape and both the second end plate 128b and the plurality of rotor bars 120 are preferably fabricated from aluminum. The means for sealingly fixing the second end 120b of each rotor bar 120 to the second end plate 128b also comprises a brazed joint at the juncture between the second end plate 128b and the second end 120b of the rotors 120.

The second end plate 128b further has a fourth internal conduit, referred to generally by reference numeral 138b. The fourth internal conduit provides fluid communication between the second coolant hole 118 and the second end 120b of the first internal conduit 124 (and alternatively both first internal conduits 124, 126) for all of the rotor bars 120 having first internal conduit(s) 124 (126). The second end plate preferably has a groove 140b on the second bore 130b in proximity to

the second coolant hole 118 which serves the same purpose as groove 140a. Preferably, the second end plate 128b, like the first end plate 128a, also has an access groove 142b covered with a cover plate 144b which is also preferably aluminum and brazed to the second end plate 128b.

It should be apparent to those skilled in the art, that two fluid paths are established by way of the configuration of the rotating machine 100 of the present invention. A first fluid path is established through the second internal conduit 108b of the rotating shaft 108. A second fluid path exists from the second internal conduit 108b, through the third internal conduit 138a of the first end plate 128a, through the first internal conduit(s) 124 (126) of the rotor bars 120, through the fourth internal conduit 138b of the second end plate 128b, and finally back to the second internal conduit 108b of the rotating shaft 108.

A circulation conduit 146 connects the inlet end 112 of the rotating shaft 108 to the outlet end 114 of the rotating shaft 108 to enclose the two fluid paths allowing circulation of a coolant fluid. A pump 148 is disposed in the fluid path of the circulation conduit 146 for establishing and driving the fluid flow in the first and second fluid paths. A heat exchanger 150 is disposed in the fluid path of the circulation conduit 146 for removing heat from the coolant fluid flowing therein.

A fluid flow means is used for establishing a circulating fluid flow through either both or one of the fluid paths previously described. To achieve a fluid flow only in the second fluid path (i.e., through the end plates 128a, 128b, and rotors 120) a full restriction

plug 152 is disposed in the second internal conduit 108a between the first and second coolant holes 116, 118 thereby diverting all of the fluid flow through the first, third, and fourth internal conduits 124 (126), 138a, 138b for each rotor bar 120 having the first internal conduit 124, (126).

However, it is preferred that both the first and second fluid flows are established thereby cooling both the rotating shaft 108 and the rotor bars 120. Both fluid flows are preferably achieved with a partial restriction plug 154 disposed in the second internal conduit 108b between the first and second coolant holes 116, 118. The partial restriction plug has an orifice 154a which creates a pressure deferential between the first and second coolant holes 116, 118 thereby diverting a portion of the fluid flow through the first, third, and fourth internal conduits 124 (126), 138a, 138b for each rotor bar 120 having the first internal conduit 124, (126) and where the remaining portion of the fluid flow continues through the second internal conduit 108b of the rotating shaft 108. Although the restriction plug is shown with the orifice 154a, it is understood that the full restriction plug 152 would not have an orifice. The pump 148 and heat exchanger 150 used as well as any fittings and connections needed for connections to and of the conduits and rotating shaft are known in the art and their descriptions omitted for the sake of brevity.

The assembly of the rotating machine 100 will now be explained with reference to Figures 2a and 2b. The at least one intermediate member 110 (referred to in Figure 1, and shown in Figures 2a and 2b as laminations

122) is assembled to the plurality of rotor bars 120 as described below.

The first end 120a of each rotor bar 120 having the at least one first internal conduit 124 (126) is assembled into place on the first end plate 128a, preferably by placement of the first end 120a into a corresponding bore 136a. Prior to or after assembly, all of the parts to be brazed are prepared for the brazing process, such as by cleaning, fluxing, etc.

The top region of a molten salts bath is heated such that the top region is maintained at a normal brazing temperature. With the top region of the molten salts bath maintained at the proper brazing temperature, only the first end plate and the first ends of the plurality of rotor bars are immersed into the top region of the molten salts bath. The first end 120a of each rotor bar 120 having the at least one first internal conduit 124 (126) is then salts brazed to the first end plate 128a.

After the salts brazing of the first end 120a of each rotor bar 120 having the at least one first internal conduit 124 (126), the second end plate 128b is assembled to the second end 120b of each rotor bar 120 having the at least one first internal conduit 124 (126). Those skilled in the art would recognize that alternatively, both the first and second end plates 128a, 128b, can be assembled before brazing of the first end plate 128a.

Similar to the first end plate 128a, only the second end plate 128b and the second ends 120b of the plurality of rotor bars 120 are immersed into the top region of the molten salts bath. The second end 120b of

each rotor bar 120 having the at least one first internal conduit 124 (126) is then salts brazed to the second end plate 128b, thereby completing the assembly.

If each of the first and second end plates 128a, 128b is provided with an access groove 142a, 142b as discussed above, then the immersion steps discussed above further include the immersion of a respective cover plate 144a, 144b and wherein the salts brazing steps include the brazing of the cover plates 144a, 144b to the respective end plates 128a, 128b to sealingly cover the access grooves 142a, 142b therein.

Finally, the first and second end plates 128a, 128b are then assembled to the rotating shaft 108. As discussed above, the preferable method for assembling the first and second end plates 128a, 128b to the rotating shaft 108 is by a shrink fit therebetween.

In summary, those skilled in the art would recognize that routing coolant through the rotor bars of the rotating machine of the present invention puts the coolant in direct contact with the source of the heat thus improving thermal dissipation and improving the design and efficiency of the rotating machine. Thus, the materials and configuration of the present invention provides an efficient, structurally sound, and producible product.

While there has been shown and described what is considered to be preferred embodiments of the invention, it will, of course, be understood that various modifications and changes in form or detail could readily be made without departing from the spirit of the invention. It is therefore intended that the invention be not limited to the exact forms described and

illustrated, but should be constructed to cover all modifications that may fall within the scope of the appended claims.

WHAT IS CLAIMED IS:

1. A rotating machine comprising;

a rotating shaft:

a plurality of conductive rotor bars spaced from the rotating shaft and fixed thereto through at least one intermediate member, at least one of the plurality of conductive rotor bars having at least one first internal conduit; and

circulation means for establishing a coolant circulation through the first internal conduit.

2. The rotating machine of claim 1, wherein the rotating shaft having a first wall defining a second internal conduit extending from an inlet end to an outlet end thereof, the rotating shaft further having first and second coolant holes in the wall and communicating with the second internal conduit, wherein the coolant is circulated through the first internal conduit from the second internal conduit by way of the first and second coolant holes.

3. The rotating machine of claim 2, wherein each of the plurality of conductive rotor bars having a first and second end, the at least one first internal conduit extending from the first to second end; the rotating machine further comprising:

a first end plate having a first bore in which the rotating shaft is sealingly fixed in proximity to the first coolant hole, the first end plate further having means for sealingly fixing the first end of each conductive rotor bar having the at least one first

internal conduit thereto, the first end plate further having a third internal conduit for each of the plurality of conductive rotor bars having the at least one first internal conduit for providing communication between the first coolant hole and the first end of the first internal conduit; and

a second end plate having a second bore in which the rotating shaft is sealingly fixed in proximity to the second cooling hole, the second end plate further having means for sealingly fixing the second end of each conductive rotor bar having the at least one first internal conduit thereto, the second end plate further having a fourth internal conduit for each of the plurality of conductive rotor bars having the at least one first internal conduit for providing communication between the second coolant hole and the second end of the first internal conduit;

wherein the circulation of coolant is established through the first, second, third, and fourth internal conduits for each conductive rotor bar having the at least one second internal conduit.

4. The rotating machine of claim 1, wherein each of the plurality of conductive rotor bars have the at least one second internal conduit.

5. The rotating machine of claim 1, wherein the at least one first internal conduit comprises two first internal conduits, each extending from the first to second end of the conductive rotor bars.

6. The rotating machine of claim 3, wherein each of the plurality of conductive rotor bars have the two first internal conduits.

7. The rotating machine of claim 1, wherein the plurality of conductive rotor bars and first and second end plates are fabricated from aluminum and where the means for sealingly fixing the first and second ends of each conductive rotor bar having the at least one first internal conduit comprises a brazed joint at the juncture between each of the first and second ends of each conductive rotor bar having the at least one first internal conduit and their respective end plate.

8. The rotating machine of claim 7, wherein the brazed joint comprises a salts brazed joint.

9. The rotating machine of claim 1, wherein the first internal conduit is cylindrical and located at an area of increased cross-section of each conductive rotor bar having the at least one first internal conduit.

10. The rotating machine of claim 5, wherein each of the two first internal conduits is cylindrical, at least one of which is located at an area of increased cross-section of each conductive rotor bar having the two first internal conduits.

11. The rotating machine of claim 3, wherein the first and second end plates are sealingly fixed to the rotating shaft by means of first and second o-ring

seals disposed on either side of its respective coolant hole.

12. The rotating machine of claim 3, wherein the plurality of conductive rotor bars are located in position relative to the first and second end plates by insertion of their respective first and second ends into corresponding counterbores on the end plates.

13. The rotating machine of claim 3, wherein each of the first and second end plates further has an access groove disposed in a fluid path of the third and fourth internal conduits, respectively, for facilitating the fabrication of the third and fourth internal conduits, and wherein the first and second end plates each further comprise a cover plate sealingly covering its respective access groove.

14. The rotating machine of claim 13, wherein each of the cover plates sealingly cover their respective access grooves by means of a brazed joint at the juncture between each of the cover plates and their respective access groove.

15. The rotating machine of claim 14, wherein the brazed joint comprises a salts brazed joint.

16. The rotating machine of claim 2, further comprising:

a circulation conduit connecting the inlet end of the rotating shaft to the outlet end of the rotating shaft; and

a pump disposed in a fluid path of the circulation conduit for establishing a coolant flow into the inlet end, through the first and second internal conduits for each conductive rotor bar having the at least one first internal conduit, and out the outlet end.

17. The rotating machine of claim 16, further comprising a heat exchanger disposed in the fluid path of the circulation conduit for removing heat from the coolant flowing therein.

18. The rotating machine of claim 3, wherein the circulation means comprises a full restriction plug disposed in the second internal conduit between the first and second coolant holes thereby diverting all of the coolant flow through the first, third, and fourth internal conduits for each conductive rotor bar having the at least one first internal conduit.

19. The rotating machine of claim 3, wherein the circulation means comprises a partial restriction plug disposed in the second internal conduit between the first and second coolant holes thereby diverting a portion of the coolant flow through the first, third, and fourth internal conduits for each conductive rotor bar having the at least one first internal conduit, whereby the remaining portion of the coolant flow continues through the second internal conduit.

20. The rotating machine of claim 1, wherein the at least one intermediate member comprises a plurality of parallel stacked laminates, each laminate

having a central bore for acceptance of the rotating shaft therein and a slot corresponding to each of the plurality of conductive rotor bars for acceptance of each of the plurality of conductive rotor bars therein.

21. The rotating machine of claim 3, wherein each of the first and second end plates further has a groove communicating with the first and second coolant holes, respectively, and each of the third and fourth conduits, respectively, for each conductive rotor bar having the at least one first internal conduit.

22. A method for assembling a rotating machine, the rotating machine comprising a plurality of conductive rotor bars spaced from a rotating shaft, each of the plurality of conductive rotor bars having a first and second end, at least one of the plurality of conductive rotor bars having at least one internal conduit extending from its first to second end; a first end plate having a first bore in which the rotating shaft is sealingly fixed, the first end plate further having means for sealingly fixing the first end of each conductive rotor bar having the at least one internal conduit thereto, the first end plate having fluid flow means for providing fluid flow to the first end of the internal conduit; and a second end plate having a second bore in which the rotating shaft is sealingly fixed, the second end plate further having means for sealingly fixing the second end of each conductive rotor bar having the at least one internal conduit thereto, the second end plate further having fluid flow means providing fluid

flow from the second end of the internal conduit, the method comprising the steps of:

assembling the plurality of conductive rotor bars to the at least one intermediate member and the first end of each conductive rotor bar having the at least one internal conduit to the first end plate;

heating the top region of a molten salts bath such that the top region is maintained at a normal brazing temperature;

only immersing the first end plate and the first ends of the plurality of conductive rotor bars into the top region of the molten salts bath;

salts brazing the first end of each conductive rotor bar having the at least one internal conduit to the first end plate;

either before or after the salts brazing of the first end of each conductive rotor bar having the at least one internal conduit, assembling the second end plate to the second end of each rotor bar having the at least one internal conduit to the second end plate;

only immersing the second end plate and the second ends of the plurality of rotor bars into the top region of the molten salts bath; and

salts brazing the second end of each conductive rotor bar having the at least one internal conduit to the second end plate.

23. The method of claim 12, wherein the fluid flow means of the first and second end plates comprises a third and fourth internal conduit, respectively, wherein the method further comprising the steps of:

providing each of the first and second end plates with an access groove disposed in a fluid path of the third and fourth internal conduits, respectively, for facilitating the fabrication of the third and fourth internal conduits; and

sealingly covering each access groove with a cover plate.

24. The method of claim 23, wherein the immersion steps further include the immersion of a respective cover plate and wherein the salts brazing steps include the brazing of the cover plates to the respective end plates to sealingly cover the access grooves therein.

25. The method of claim 22, further comprising the step of assembling the first and second end plates to the rotating shaft.

26. The method of claim 25, wherein the assembling of the first and second end plates to the rotating shaft comprises the steps of:

heating each of the first and second end plates so as to expand the diameter of the first and second bores therein; and/or

cooling the rotating shaft so as to decrease the diameter thereof; and

normalizing the temperatures of the first and second end plates and/or the rotating shaft such that the first and second end plates are shrink fit to the rotating shaft.

ROTATING MACHINE WITH COOLED HOLLOW ROTOR BARS

ABSTRACT OF THE DISCLOSURE

A rotating machine including a rotating shaft: a plurality of conductive rotor bars spaced from the rotating shaft and fixed to the rotating shaft through at least one intermediate member, where at least one of the plurality of conductive rotor bars have at least one first internal conduit; and a circulator for establishing a coolant circulation through the first internal conduit.

007290 "EP2865560

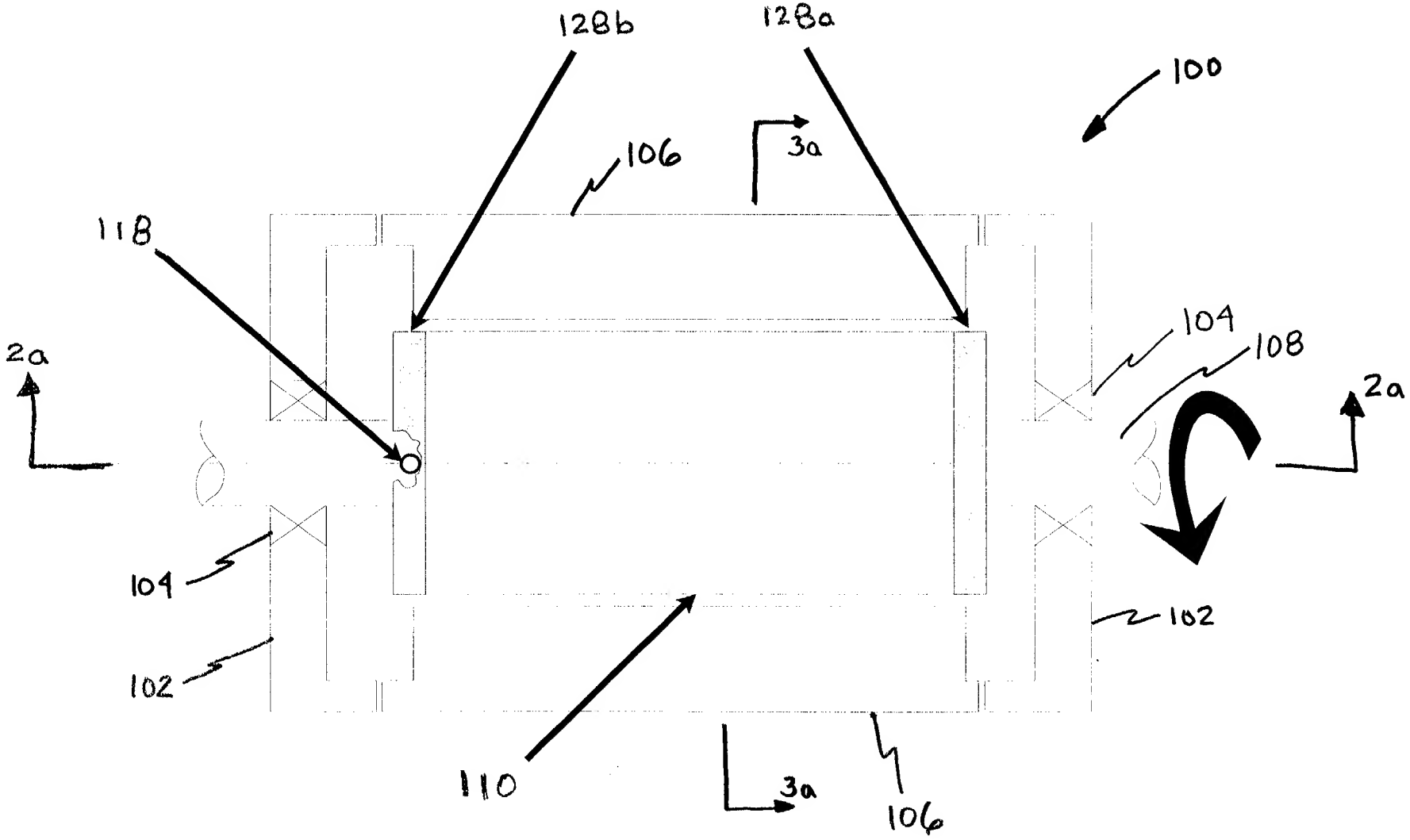
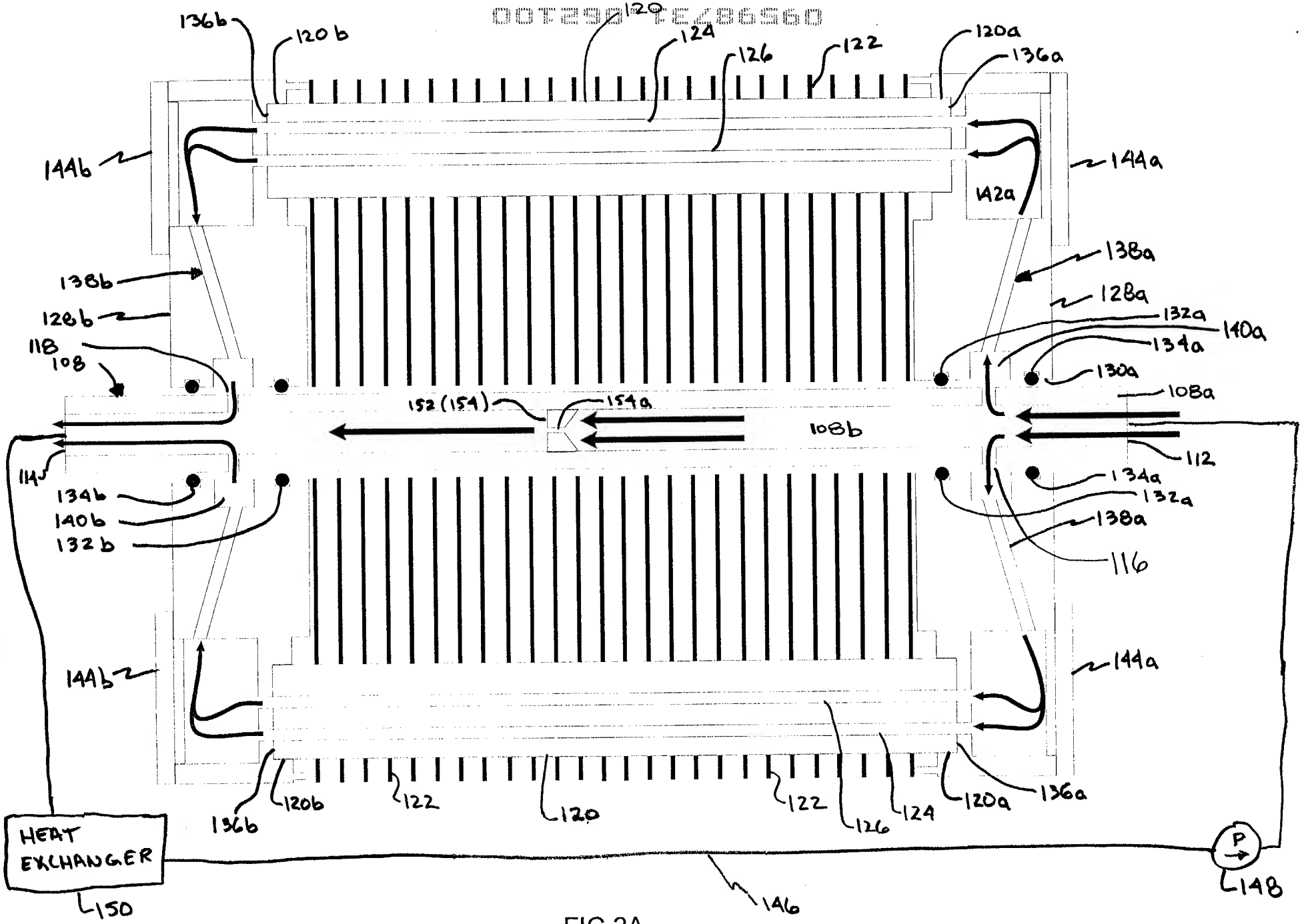


FIG 1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140a
134a
130a
118
108
108a
152 (154)
154a
108b
112
114
134b
140b
132b
116
HEAT EXCHANGER
150
146
148
P

FIG 2A

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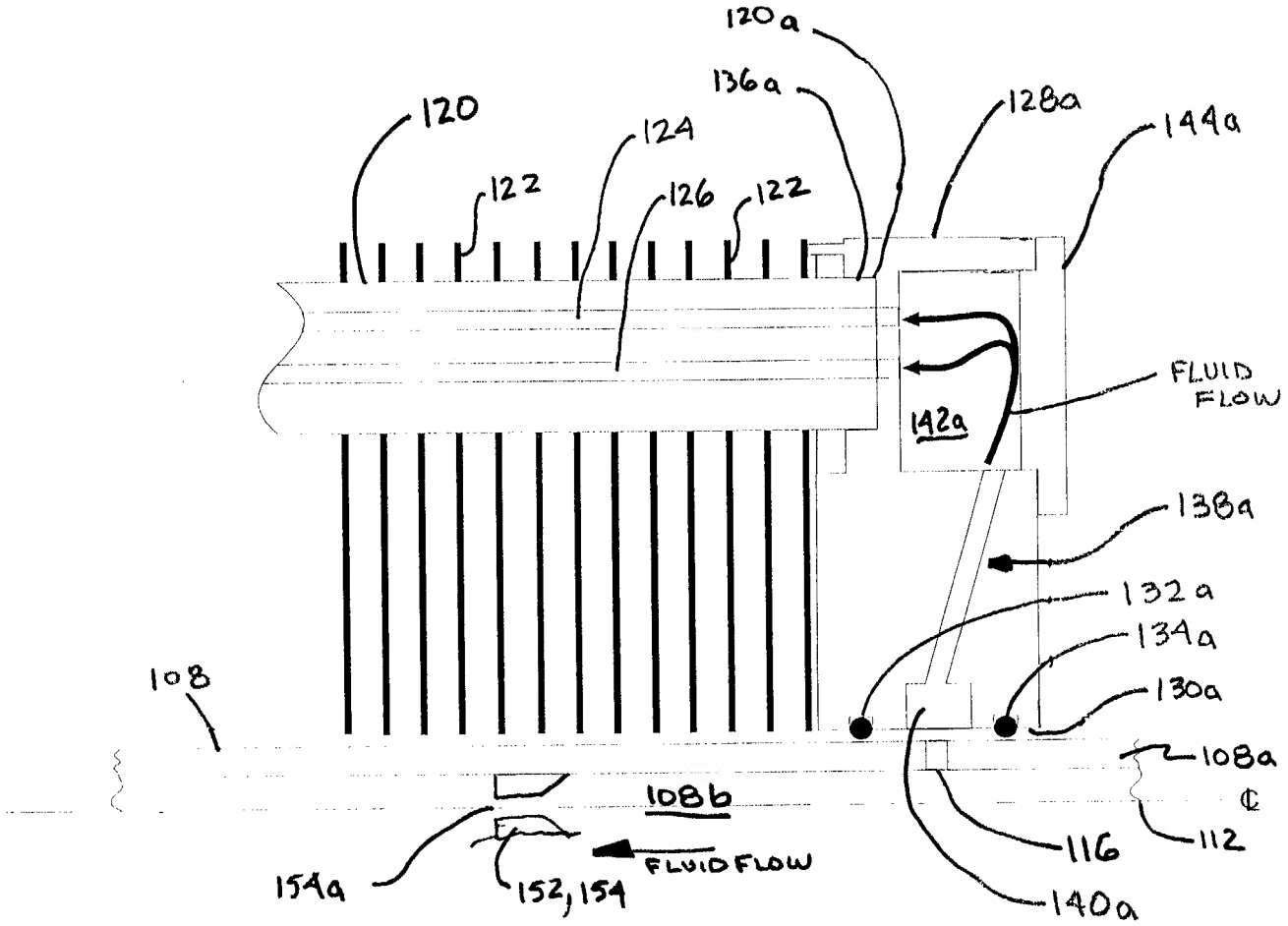

FIG 2b

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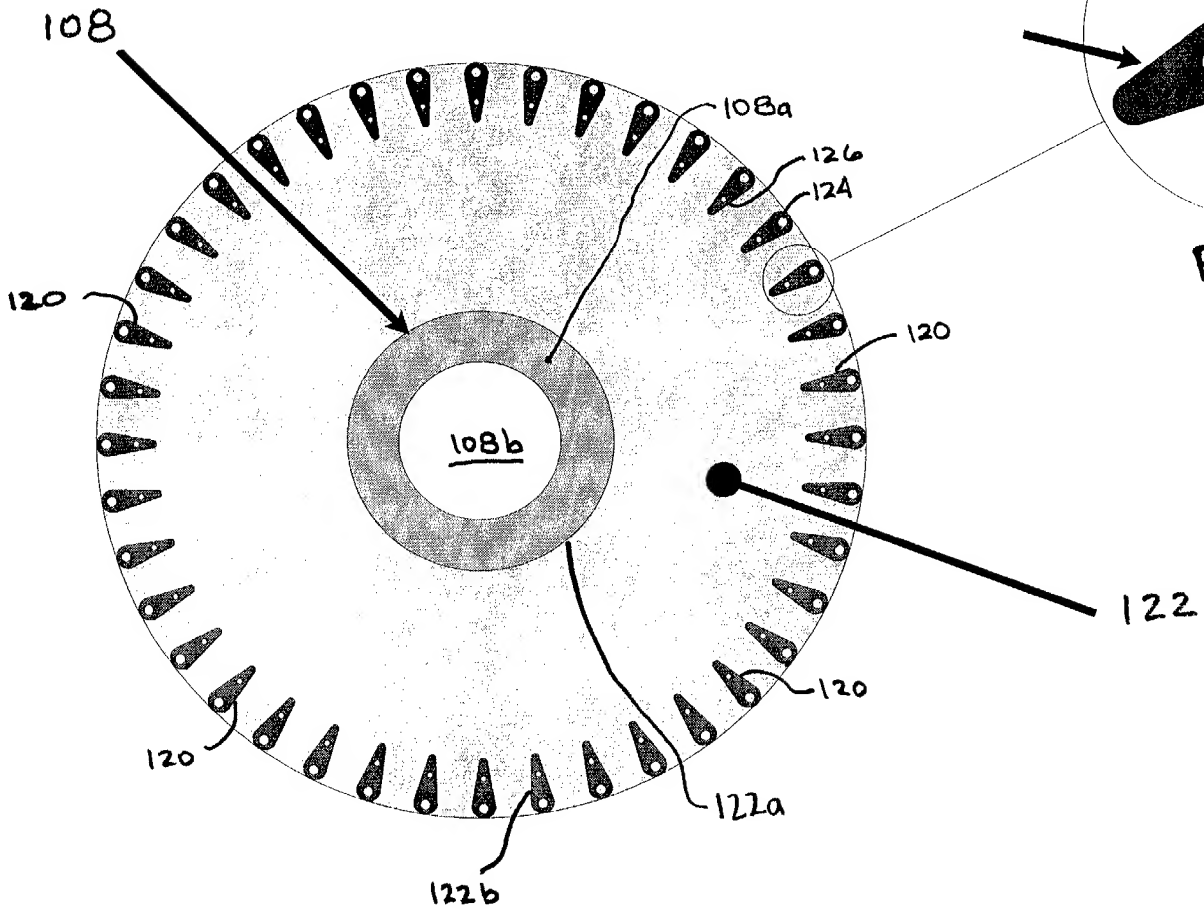

FIG.3a

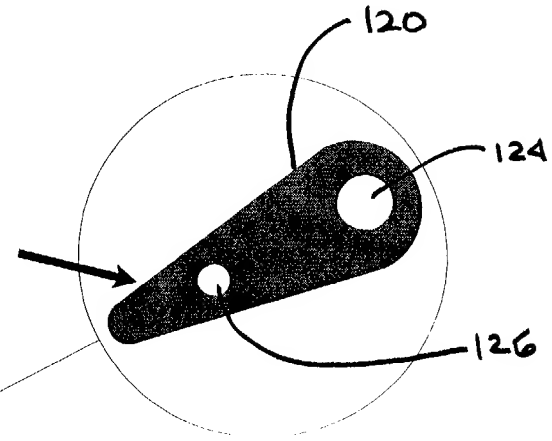

FIG. 3b

Lockheed Martin Docket 52AY1371

Docket No.
13368

Declaration and Power of Attorney For Patent Application

English Language Declaration

As a below named inventor, I hereby declare that:

My residence, post office address and citizenship are as stated below next to my name,

I believe I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled

ROTATING MACHINE WITH COOLED HOLLOW ROTOR BARS

the specification of which

(check one)

☒ is attached hereto.

☐ was filed on _____ as United States Application No. or PCT International Application Number _____

and was amended on _____

(if applicable)

I hereby state that I have reviewed and understand the contents of the above identified specification, including the claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose to the United States Patent and Trademark Office all information known to me to be material to patentability as defined in Title 37, Code of Federal Regulations, Section 1.56.

I hereby claim foreign priority benefits under Title 35, United States Code, Section 119(a)-(d) or Section 365(b) of any foreign application(s) for patent or inventor's certificate, or Section 365(a) of any PCT International application which designated at least one country other than the United States, listed below and have also identified below, by checking the box, any foreign application for patent or inventor's certificate or PCT International application having a filing date before that of the application on which priority is claimed.

Prior Foreign Application(s)			Priority Not Claimed
_____ (Number)	_____ (Country)	_____ (Day/Month/Year Filed)	☐
_____ (Number)	_____ (Country)	_____ (Day/Month/Year Filed)	☐
_____ (Number)	_____ (Country)	_____ (Day/Month/Year Filed)	☐

I hereby claim the benefit under 35 U.S.C. Section 119(e) of any United States provisional

(Application Serial No.)	(Filing Date)
(Application Serial No.)	(Filing Date)
(Application Serial No.)	(Filing Date)

I hereby claim the benefit under 35 U. S. C. Section 120 of any United States application(s), or Section 365(c) of any PCT International application designating the United States, listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States or PCT International application in the manner provided by the first paragraph of 35 U.S.C. Section 112, I acknowledge the duty to disclose to the United States Patent and Trademark Office all information known to me to be material to patentability as defined in Title 37, C. F. R., Section 1.56 which became available between the filing date of the prior application and the national or PCT International filing date of this application:

(Application Serial No.)	(Filing Date)	(Status) (patented, pending, abandoned)
(Application Serial No.)	(Filing Date)	(Status) (patented, pending, abandoned)
(Application Serial No.)	(Filing Date)	(Status) (patented, pending, abandoned)

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

PTO/SB/08A (6-95)

POWER OF ATTORNEY: As a named inventor, I hereby appoint the following attorney(s) and/or agent(s) to prosecute this application and transact all business in the Patent and Trademark Office connected therewith. *(list name and registration number)*

Stephen D. Murphy; Reg. No. 22,002
Leopold Presser; Reg. No. 19,827
William C. Roch; Reg. No. 24,972
Kenneth L. King; Reg. No. 24,223
Frank S. DiGiglio; Reg. No. 31,346
Paul J. Esatto, Jr.; Reg. No. 30,749
John S. Sensny; Reg. No. 28,757
Mark J. Cohen; Reg. No. 32,211
Richard L. Catania; Reg. No. 32,608
Edward W. Grolz; Reg. No. 33,705
Geoffrey H. Krauss; Reg. No. 27,343

Send Correspondence to: **Paul J. Esatto, Jr.**
Scully, Scott, Murphy & Presser
400 Garden City Plaza
Garden City, New York 11530

Direct Telephone Calls to: *(name and telephone number)*
Paul J. Esatto, Jr. at (516) 742-4343

Full name of sole or first inventor
Roy R. Weidman

Sole or first inventor's signature — Date
Roy R. Weidman — 6/5/00

Residence
Apalachin, New York

Citizenship
U.S.A.

Post Office Address
12 Brown Lane

Apalachin, New York 13732

Full name of second inventor, if any
Thomas Benjamin Hobbs

Second inventor's signature — Date
Thomas Benjamin Hobbs — 6/2/00

Residence
Nichols, New York

Citizenship
U.S.A.

Post Office Address
2320 Stanton Hill Road

Nichols, New York 13812